Quality Control

Work Order II November-21-11 11:0			*767	773*/						Page 1
Item ID: D328 Revision ID: Item Name: Space			Accept	*N900	<u>040</u>	100)* s	Setup Star	1.71	S1* S2*
Start Date: 21/11 Required Date: 02/01 Reference:				Cust Item 1 Customer:	D:					
Approvals: Proc	ess Plan: M.L.J	Date: <u>11 11 2 </u> Date:	Tooling: SPC (Y/N):		ate:		R	Run Star Stop	, "I V I	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								······ -••	
D3286	Rev A									
100	Hardinge CNC LATHI	E SMALL	0.00				100	O		Stulidi
Hardinge Hardinge CNC Lathe Small		ks as per Folio FA434 and Dw [per Dwg D3286	0.00 g D3286							. •
110	QC2- Inspect parts off	machine FAI/FAIB	0.00				1200	Ò		Mulala?
110 QC Quality Control	Memo		0.00				100			<u>ng miarze</u>
	,									
*120 *120* oc	QC8- Inspect parts - se	cond check	0.00	TG 11.13	2 · 2 3		(00			

	-								
W/O:			W	ORK ORDER CHANG	iES		*		
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		.,							
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA	\:	Date: _	
	Re	esolution:	Disposition	on:	_ QA: N/C C	losed:	·	Date: _	
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NC	R)	, <u>, , , , , , , , , , , , , , , , , , </u>		
DATE	CTED	Description of NC			tion B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	k Section		Chief Eng	QC Inspector
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				-					
		,							
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Work Order ID 76773 *76773* Page 2 November-21-11 11:07:44 AM *N900040100* Item ID: D3286-3 Accept Setup Start **Revision ID:** Item Name: Spacer *100* **Start Qty: 100.00 Start Date:** 21/11/2011 **Cust Item ID: Required Date:** 02/01/2012 Req'd Qty: 100.00 *100* **Customer:** Reference: Run Process Plan: Date: _____ Tooling: Date: Approvals: Stop Date: SPC (Y/N): OC: Date: Tool # Plan Reject Reject Sequence ID/ Set Up/ Tool ID Accept Insp. Operation Oty Qty Number Stamp Description Code **Work Center ID Run Hours** Identify as per dwg & Stock Location 0.00 130 *120* Packaging 0.00 Memo ***STOCK IN SKIDTUBE CELL*** Packaging

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

*14**0***

Quality Control

n 112/28

MIL-18 (104)

W/O:			V	VORK ORDER CHANG	ES			
DATE	STEP	PRO	DCEDURE CH	HANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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,								
					·			
Part No:		PAR #:	Fault Ca	tegory:	NCR: Yes	lo DQA:	Date: _	
	R	lesolution:	Disposit	ion:	_ QA: N/C Clo	sed:	Date: _	
NCR:		*	WORK OR	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		,						
					-			
	:							

Picklist Print

November-21-11 11:07:49 AM

Work Order ID: 76773

Parent Item:

D3286-3

Parent Item Name: Spacer

76773

D3286-3

Start Date: 21/11/2011

Required Date: 02/01/2012

Date

Issued

Page 1

Status

Start Qty: 100.00

Required Qty: 100.00

Comments:

IPP A04.07.14New issueKJ/JLM

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand		Qty	Issued
M304TR0.500W.049		Purchased	No			110	f	287.2801	0.3417	35.96842	

M304TR0 500W 049

304 RD Tube .500 x .049W

Location	Loc Qty	Loc Code	
MAT017	287.280058		
111814 _ \	2.23		
115010	145.421058		30.000
117598	49.87		
119087	89.759		6.167

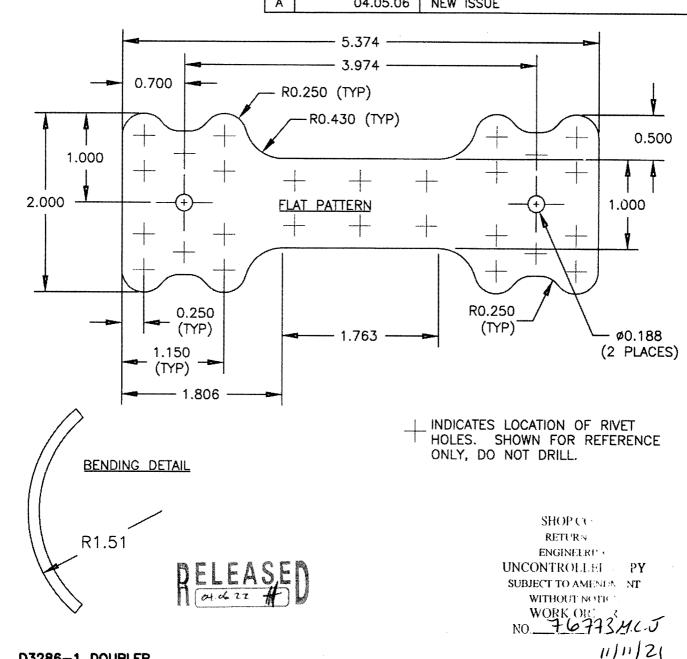
W/O:			M	ORK ORDER CHANGE	ES			
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	_							
								,
Part No:	`	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Disposit	ion:	QA: N/C Clo	sed:	Date: _	
NCR:		V	ORK OR	DER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DAIL	SILP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
<u> </u>								







DESIGN (1)	DRAWN BY	DART A		PACE ADLOCK, V		INC	•
CHECKED.	APPROVED -	DRAWING NO.			SHEE		V. A OF 2
DATE		TITLE				S	CALE
04.05.06		GROUND HAI	NDLING	PARTS			1:1
Α	04.05.06	NEW ISSUE					*****



D3286-1 DOUBLER

1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK

(REF DART SPEC. M304S11GA)

- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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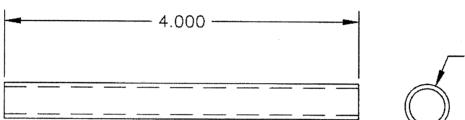
W/O:			٧	VORK ORDER CHANGI	ES			-	
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Ca	tegory:	NCR: Yes	No DO	A:	Date:	
	R	esolution:	Disposit	ion:	QA: N/C	Closed: _		Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verif	ication	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	tion C	Chief Eng	QC Inspector
				·					

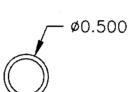






DESIGN	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V		NC.	
CHECKED	APPROVED,	DRAWING NO.			REV.	A
1 #-	*#t	D3286		SHEET	2 OF	2
DATE		TITLE		······································	SCAL	Œ.
04.05.06		GROUND I	HANDLING PARTS		1	:1





D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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.							<u>.</u>	Amazaina		
Part No		PAR #:								
	R	esolution:							Date: _	
NCR:		V	WORK OR	DER NON-CONFOR	RMANCE	(NCR)				
DATE	STEP	Description of NC	11411		Section B	Ciam 0	Verifica		Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Descripti Chief Eng	on	Sign & Date	Sectio	n C	Chief Eng	QC Inspector
	· ·									
					* \$6					
7次4种										

DART AEROSPACE LTD	Work Order:	76773
Description: Spacer	Part Number:	D3286-3
Inspection Dwg: D3286 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	X First Article		Prototype			
Drawing	Tolerance	Actual	Accept	Reject	Method		

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments		
Dimension		Dimension			Inspection			
4.000	+/-0.010	3.999 0.500			5L08			
0.500	+/-0.010	0.500			SL08			
					,			
			-					
			·					
						- 10		

Measured by:	Audited by: (24)	Prototype Approval: N/A
Date: 11/12/22	Date: (1、12・23	Date: N/A

Rev	Date	Change	Revised by	Approv <i>e</i> d
Α	04.09.01	New Issue	KJ/JLM o	
				7707

Dart Aerospace	Ltd	
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W/O:			V	VORK ORDER CHAN	IGES						
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action S Action Description Chief Eng	ection B	Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector	
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